

Work Order ID 158322

Monday, March 20, 2017 11:19:39 AM

Ship April 5th

Page 1

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017 Start Qty: 10.00

Required Date: 4/5/2017 Req'd Qty: 10.00

Reference: SCHEDULE/C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: mf Date: 17-3-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

DAS
28
9-89

APR 07 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

D

DAS
28
9-89

APR 08 2017

110

Large Fab

0.00

110

Large Fab

Memo

4.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg
D3272A/R Aluminum Rod 134785

3-Grind End Plate flush

← 10x DC 2017/03/29

CS 10

DAS
24
9-89

MAR 28 2017

B#158322 x10 x RH

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Reference: SCHEDULE/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.20							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	4.10							
Hand Finishing									

(RH x10) *201704103*
BEB.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						10	APR 03 2017		DAS 24 9-89
QC	Memo	0.10							
Quality Control									

180		0.00							
180	Large Fab								
Large Fab	Memo	4.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod 1308ss								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

Handwritten notes: 10x DG 2017/04/04, CSM 17/04/04, 10x DG 2017/04/05

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<u>10</u>			DAS 38 9-88 APR 05 2017
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				<u>20</u>			DAS 38 9-88 APR 05 2017
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 1.00				<u>(X10) 0</u>			201704105 BER

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 136657. 1137116</i> Memo START TIME: <i>11:45.</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:15.</i>	0.00 2.10				<i>10</i>	<i>0</i>	<i>17-04-06</i>	<i>333</i>
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>1137092</i> Memo	0.00 2.20							<i>201704106</i> <i>BEB</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<i>10</i>			<i>DAS</i> <i>38</i> <i>9-88</i> <i>APR 17 2017</i>

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Required Date: 4/5/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULE/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00				APR 0 7 2017			
250									
Packaging	Memo	0.10							DAS 6 27 9-89
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.30							DAS 28 9-89
Quality Control									APR 0 8 2017
270	Packaging	0.00							
270									
Packaging	Memo	0.00							DAS 27 9-89
Packaging	Identify and pack for shipping as per PPPD350-591-312 Location :FG072								DAS 28 9-89

sold

APR 10 2017

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Required Date: 4/5/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCHEDULE/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	1.00					DAS 21 9-89		APR 11 2017
Quality Control									

DAS
21
9-89 APR 11 2017

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-35A

Purchased

No

250

Each

52.0000

2

20

AN3-35A

Bolt

**

APR 07 2017

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

42

M137073

42

AN4-13A

Purchased

No

250

Each

278.0000

8

80

AN4-13A

Bolt

**

APR 07 2017

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

76

m134634

19

m135470

57

ST344

182

m136787

132

m137073

50

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

37.0000

2 20

AN5-36A

Bolt

**

APR 07 2017 **DAS 27 9-89**

DAS 28 9-89

Location

Loc Qty

Loc Code

ST336

37

m137075

37

20

D2230-3

Manufactured

No

250

Each

73.0000

4 40

D2230-3

Mounting Lug

**

APR 07 2017 **DAS 27 9-89**

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

6

109344

4

89045

2

ST321

3

154877

3

ST521

64

157193

64

40

D2618

Manufactured

No

250

Each

15.0000

2 20

D2618

Bushing

**

158324x14 **DAS 27 9-89**
APR 07 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST008A

15

156820

15

D2856-400

Manufactured

No

250

f

131.5510

1.2 12

D2856-400

Abrasion Strip 4" Wide (Per Foot)

**

DAS 27 9-89
APR 07 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST418

131.5509953

146265

27.4088853

152590

104.14211

156030

cut (2) D2856-400-720 as per dwg

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D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

✓ D3065-041

Manufactured No

180 Each 12.0000 1 10

D3065-041

Step Leg Assembly

**

DC 2017/04/04

Location

Loc Qty

Loc Code

WA003

12

B158801 →

8

154235

4

B157217 →

2

157217

8

✓ D3066-1

Manufactured No

180 Each 29.0000 2 20

D3066-1

Spacer

**

DC 2017/04/04

Location

Loc Qty

Loc Code

WA003

29

B158015 →

20

157321

9

158015

20

D3067-1

Manufactured No

110 Each 37.0000 1 10

✓ ***D3067-1***

End Plate

**

MAR 28 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

37

3158246 → 10

150703

1

156300

36

✓ D3067-1

Manufactured No

180 Each 37.0000 1 10

D3067-1

End Plate

**

Location

Loc Qty

Loc Code

WA003

37

150703

1

156300

36

CS(10) 17/04/1040

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D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

✓ D3219-1
D3219-1
Plate

Manufactured No

110

Each

40.0000

2

20

**

MAR 28 2017

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

40

146684

2

149190

12

151196

4

157987

22

D3235-1
D3235-1
Mounting Lug

Manufactured No

250

Each

22.0000

2

20

**

DAS
23
9-89

APR 17 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

ST522

22

156730

22

✓ D3272-1
D3272-1
Step

Manufactured No

110

Each

0.0000

1

10

**

B158323 → 10 MAR 28 2017

DAS
24
9-89

D3278-041
D3278-041
Support Assembly

Manufactured No

250

Each

26.0000

1

10

**

DAS
26
9-89

APR 17 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

ST522

26

151903

26

Picklist Print

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D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

1,113.000

16

160

MS20600-AD4W4

**

Rivet

2017/04/04

Location

Loc Qty

Loc Code

CCK004

511

B136986 → 1160

M135704

11

M137075

500

ST308

2

M133990

2

WA003

600

M135442

204

M136986

396

MS21042L3

Purchased

No

250

Each

1,920.000

2

20

MS21042L3

**

Nut

989 DAS

APR 07 2017

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

222

m134360

102

M136665

120

OVER007

300

m134360

0

M136665

300

ST303

1298

M136554

297

M136838

1

m137073

1000

20

*DAS
28
9-89*

*DAS
27
9-89*

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Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

1,383.000

8

80

MS21042I 4

Nut

**

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

183

m135058

183

OVER007

500

m136986

500

ST303

690

m136450

500

m136838

190

MS21042L5

Purchased

No

250

Each

313.0000

2

20

MS21042I 5

Nut

**

Location

Loc Qty

Loc Code

GA

21

m127813

21

ST303

292

m136450

2

m136866

65

m136986

150

m137075

75

DAS
28
9-89

APR 07 2017
DAS
27
9-89

DAS
28
9-89

DAS
28
9-89

APR 07 2017
DAS
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9-89

DAS
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22
20

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Start Date: 3/20/2017

Required Date: 4/5/2017

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0363J

Purchased

No

250

Each

633.0000

4

40

NAS1149D0363.I

Washer

**

DAS
6
9-89

APR 07 2017 DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

159

m134055

159

ST260a

100

m137061

100

ST263

374

m136781

374

NAS1149D0463J

Purchased

No

250

Each

2,117.000

16

160

NAS1149D0463.I

Washer

**

DAS
6
9-89

APR 07 2017 DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST2360A

1000

M136983

1000

ST263

1037

M136665

37

M136838

1000

NAS1149D0563J

Purchased

No

250

Each

998.0000

4

40

NAS1149D0563.I

Washer

**

DAS
6
9-89

APR 07 2017 DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

187

m135774

187

ST263

811

m136295

111

m136986

700

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04-*H*

MF
#158320



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

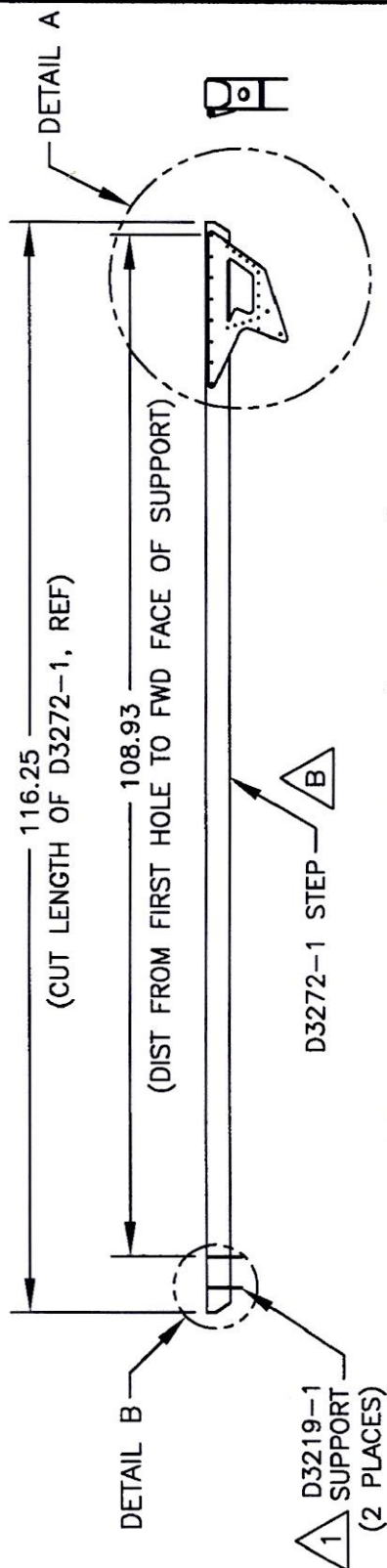
QA Closed: _____ Date: _____

Work Order update only ☐

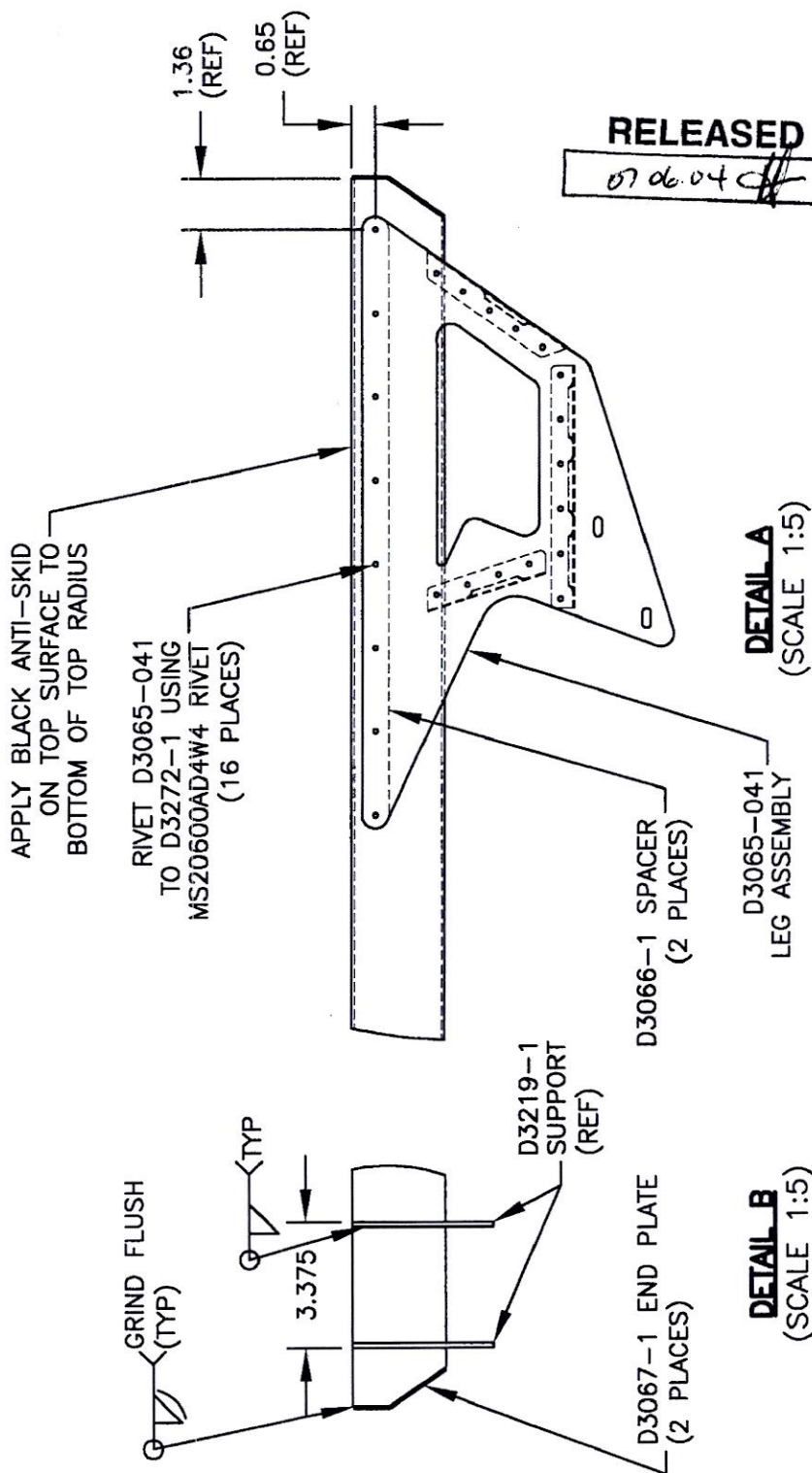
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



DESIGN GP	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

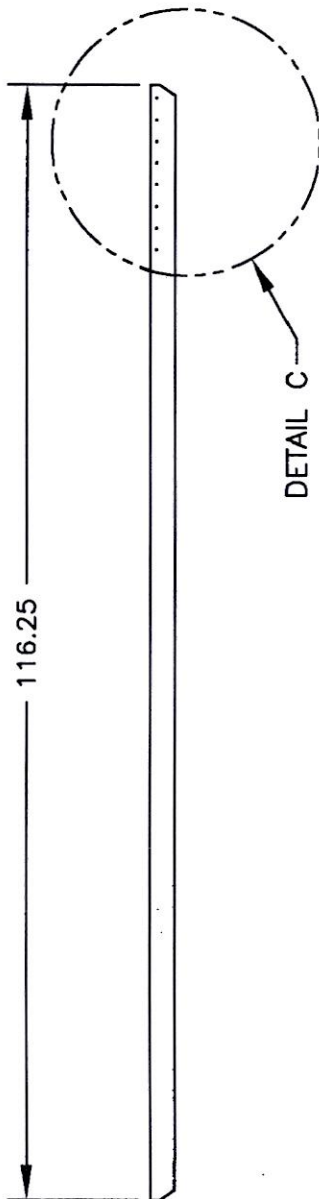
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

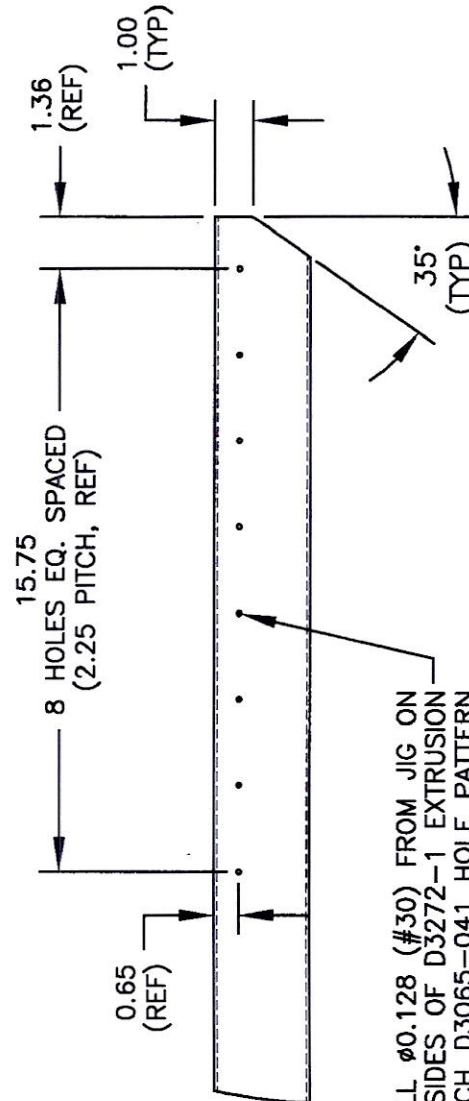
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-38A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Work Order ID 158322

Monday, March 20, 2017 11:19:39 AM

158322

Ship April 5th

Page 1

Item ID: D350-591-312

Revised ID:

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 3/20/2017 Start Qty: 10.00

Required Date: 4/5/2017 Req'd Qty: 10.00

Reference: SCHEDULE/C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: *mf*

Date: *7-3-20*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Drawing Nbr

Revision Nbr

D3272

Rev B

APR 07 2017

100

Document Control

0.00

100

DC

Memo

0.00

Doc Control-USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

DAS
21
9-89

APR 10 2017

10

110

110

Large Fab

Large Fab

0.00

Memo

4.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *134785*

3-Grind End Plate flush

10x D 2017/03/27

CS 10

DAS
24
9-89

MAR 28 2017